

Work Order ID 50052

July 7, 2009 8:25:07 AM

Page 1

Item ID: D412-760-011
Revision ID: B
Item Name: Cabin Floor Protector

Accept

Setup Start

Stop

Start Date: 07/07/2009 Start Qty: 1.00

Required Date: 07/07/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev B

100

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-760-011 CHG0012

09/07/07

09/07/07

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

09/07/07

see w/o 47674 attach
see B2

Russ pulled 1 kit D412-760-011 from
stock B 47674 for testing.
Repackage and return to stock.
Ensure all parts and hardware are
good.
New labels are required under
new batch number.

mtf 09-07-07
- mtf 07-07

Work Order ID 50052

July 7, 2009 8:25:07 AM



Page 2

Item ID: D412-760-011
Revision ID: B
Item Name: Cabin Floor Protector

Accept



Setup Start



Stop



Start Date: 07/07/2009 Start Qty: 1.00



Required Date: 07/07/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-760-011 Location: _____ L: PPP Rev: B

Rec'd 7/7 ①

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

09/07/07

Quality Control

MF 09-07-10

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Job Date	Secrap	Up	Quam	meind	N:C	ILCX	Sortme	Offse	an	Ty 1	Per	Och	to	lore	C3	Last	Id	Da
✓	AN960JD10		Washer	01/01/2008	28...	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	AN960JD416		Washer	01/01/2008	12...	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3574-1	B	Cabin Floor Protec...	01/01/2008	1....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3574-2	B	Cabin Floor Protec...	01/01/2008	1....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3575-1	A	Cabin Floor Protec...	01/01/2008	1....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3575-2	A	Cabin Floor Protec...	01/01/2008	1....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3580-1	B	Joggle Bracket	01/01/2008	6....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3628-1	B	Cupped Washer	01/01/2008	14...	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	D3628-3	B	Cupped Washer	01/01/2008	6....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	MS24694-S100		FLAT HEAD SCREW	01/01/2008	6....	Ea		120	0	0.0...					0	0	M...					06/...	06...		
✓	MS24694-S54		Screw	01/01/2008	14...	Ea		120	0	0.0...					0	0	M...					06/...	06...		

REFERENCE ONLY

Date: Monday, 04/05/2009 10:18:31 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN FLOOR PROTECTOR KIT
 Job Number : 47674
 Estimate Number : 12936
 P.O. Number :
 This Issue : 04/05/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D412760011
 First Issue : 11 Drawing Number : N/A
 Previous Run : 46507 Type : SMALL /MED FAB Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 11/05/2009 Qty: 6 Cx 09/05/14
 Written By :
 Checked & Approved By : MF 09-05-04
 Comment : est rev A 07.07.05 new issue EC
 Est Rev:B 08-08-20 revB as per dwg DD verified by:ec
 Est Rev C 09.04.14 chg002 EC verified by: DD

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for JLD 09/05/11



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-760-011 CHG002

6 09/05/15

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D35741 Cabin Floor Protector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: 1347788 ✓

4.0 D35742 Cabin Floor Protector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: 1347788 ✓

5.0 D35751 Cabin Floor Protector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: 47792 ✓

Date: Monday, 04/05/2009 10:18:31 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR KIT

Job Number: 47674

Part Number: D412760011

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation:

Description :

6.0 D35752 Cabin Floor Protector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: 97793 ✓ +

9/10/14

7.0 D35801 Joggle Bracket



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

JOGGLE BRACKET

batch: B46513 18X

9/15/12 B47787 18X

8.0 D36281 Cupped Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

CUPPED WASHER

batch: 1532923

B43033

9/15/12

9.0 D36283 Cupped Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

CUPPED WASHER

batch: 1532924 ✓

9/15/12

10.0 MS24694S54 Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

Screw

batch: M110715

M107946

M111434 53X

M111724 28X

11.0 MS24694S100 FLAT HEAD SCREW



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

FLAT HEAD SCREW

batch: M108701 ✓

9/15/12

12.0 AN960JD10 Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total: 112.0000 Each(s)

Washer

batch: M111279

9/15/12

Date: Monday, 04/05/2009 10:18:31 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR KIT

Job Number: 47674

Part Number: D412760011

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD416

Washer



(8x)

Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch: 1110363

9/5/09

5/1

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/05/15

(1x)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-760-011

Location:

PPP Rev: B

10/05/15 (6)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/15

Job Completion



MF
09-05-14

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	QTY -111	QTY -211	Part Number	Description
X						D412-760-011	CABIN FLOOR PROTECTOR KIT
	X					D412-760-013	CABIN FLOOR PROTECTOR KIT
		X				D412-760-015	CABIN FLOOR PROTECTOR KIT
			X			D412-760-017	CABIN FLOOR PROTECTOR KIT
				X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
					X	D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
1						D3574-1	CABIN FLOOR PROTECTOR ✓
1						D3574-2	CABIN FLOOR PROTECTOR
	1					D3574-3	CABIN FLOOR PROTECTOR
	1					D3574-4	CABIN FLOOR PROTECTOR
		1				D3574-5	CABIN FLOOR PROTECTOR
		1				D3574-6	CABIN FLOOR PROTECTOR
1						D3575-1	CABIN FLOOR PROTECTOR ✓
1						D3575-2	CABIN FLOOR PROTECTOR ✓
	1					D3575-3	CABIN FLOOR PROTECTOR
	1					D3575-4	CABIN FLOOR PROTECTOR
		1				D3575-5	CABIN FLOOR PROTECTOR
		1				D3575-6	CABIN FLOOR PROTECTOR
			1			D3788-1	CABIN FLOOR PROTECTOR
			1			D3788-2	CABIN FLOOR PROTECTOR
			1			D3788-3	CABIN FLOOR PROTECTOR
			1			D3788-4	CABIN FLOOR PROTECTOR
6	4	6	6			D3580-1	JOGGLE BRACKET ✓
14	40	14	14		36	D3628-1	CUPPED WASHER ✓
6	8	6	6			D3628-3	CUPPED WASHER ✓
					1	D3876-1	RH FORWARD WALL PROTECTOR
					1	D3876-3	FORWARD WALL PROTECTOR
					1	D3876-5	LH WALL PROTECTOR
					1	D3876-7	AFT WALL PROTECTOR
					1	D3876-9	RH AFT WALL PROTECTOR
					1	D3876-11	FLOOR PROTECTOR
					1	D3876-13	DOOR PROTECTOR
				1		D3933-1	LH AFT CABIN WALL PROTECTOR
				1		D3933-2	RH AFT CABIN WALL PROTECTOR
				1		D3935-1	LH PYLON PROTECTOR
				1		D3935-2	RH PYLON PROTECTOR
				14		D3942-1	ANGLE
				10		D3942-3	CLIP
					1	D3952-1	PLACARD
					36	80-004-2-6	INSERT
28		28	28			AN960JD10	WASHER ✓
12		12	12			AN960JD416	WASHER ✓
14		14	14			MS24694S54	SCREW ✓
6		6	6			MS24694S100	SCREW ✓
					36	MS27039-1-04	SCREW
				4		MS27039-4-10	SCREW
				6		MS27039-4-14	SCREW
				6		MS27039-5-8	SCREW
				8		MS27039-5-12	SCREW